



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5237-7**Job Sheet 189696****Part No:** D5237-7**Job Qty:** 8 pcs**Part Name:** Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/29/19**Job Tracking No:****Due Date:** 2/22/19**Created By:** Jesse White**Type:** Stock**Description:** SIOP**Note:** DWG REV B IPP Rev:A RQ 15.06.03 Verified by: DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		2/22/19	0.00	0.00	Bandsaw - 1		19-05-28
105	HAAS 5 Axis - B4B	8 pcs		2/22/19	1.36	9.64	HAAS - 5 - B4B		19-06-01
110	QC 2	8 pcs		2/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-06-01
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		

**Container No:** S184726**Part No:** D5237-7**Job No:** 189696**Serial No/Batch:** S184726**Revision:****Inspector:****Ship Date:****Instructions:** Various STC's**Date:** 05/28/19

Dart Aerospace Ltd.
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CANADA
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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

120 QC 8	8 pcs	2/22/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	23
				QC 8 - 3	148 19/6/3
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
130 Handfinish - 1-1 Chemical-B4B	8 pcs	2/22/19	0.00 0.53	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 QC 7	8 pcs	2/22/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
170	Packaging 3-1 - Stock - B4B	8 pcs	2/22/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B

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Other/Details: 04 09-9					

180 QC 21 - SA		8 pcs	2/22/19	0.00 0.00	Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	21
					QC 21 - SA - 70	21
Part Op 100 - (Bandsaw) cut blank 5.625" long Descriptions: 105 - (HAAS CNC vertical machine #5) 1-MILL as per Dwg 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 140 - (QC7-Inspect Chemical Conversion Coat) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)						JUN 05 2019 9:59
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M6061T6B2.000X04.500	6061T6 Bar 2.00 X 4.500	3.7440 ft (.468 ea)	100-Bandsaw - 1	FM 138 361		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Bandsaw - 1	M6061T6B2.000X04.500	4	14	0		
Part Specifications						
Specifications could not be found.						

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Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D5237-7
Inspection Dwg: D5237 Rev: B		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	.496	✓		SLIO	Vern
Ø0.201	+0.005/-0.001	.203	✓			
1.500	+/-0.005	1.500	✓			
2.530	+/-0.005	2.530	✓			
1.500	+/-0.005	1.500	✓			
0.88	+/-0.030	.875	✓			
0.650	+0.030/-0.000	.670	✓		gauge	Pin
0.460	+0.005/-0.000	.461	✓		"	
0.10	+/-0.030	.104	✓		SLIO	Vern
1.15	+/-0.030	1.167	✓			
0.100	+0.000/-0.005	.098	✓			
0.44	+/-0.030	.444	✓			
0.34	+/-0.030	.347	✓			
2.260	+/-0.005	2.261	✓			
0.380	+0.000/-0.002	.3787	✓			
0.66	+/-0.030	.655	✓			
Ø0.252	+0.005/-0.000	.253	✓			
2.100	+/-0.005	2.102	✓			
1.92	+/-0.030	1.920	✓			
R0.19	+/-0.030	.190	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
0.25	+/-0.030	.249	✓			
R0.15	+/-0.030	.150	✓		Rad gauge	
R0.06	+/-0.030	.060	✓			
0.92	+/-0.030	.925	✓		SLIO	
76°	+/-0.5°	76°	✓		Protractor	
3.84	+/-0.030	3.842	✓		Height gauge	
4.03	+/-0.030	4.029	✓			
5.03	+/-0.030	5.030	✓			
0.38	+/-0.030	.376	✓			
R0.20	+/-0.030	.200	✓		Rad gauge	
R2.00	+/-0.030	2.000	✓			
0.38	+/-0.030	.375	✓		SLIO	
R1.00	+/-0.030	1.000	✓		Rad gauge	
3.90	+/-0.030	3.901	✓		SLIO	
86°	+/-0.5°	86°	✓		Protractor	
2.39	+/-0.030	2.386	✓		SLIO	
Ø0.201	+0.005/-0.001	.202	✓		"	
Ø0.385 x 100°	+/-0.010 x +/-0.5°	.390	✓		"	

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
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